

NCR-19-7395



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RBW6305G11331-3G-09

Job Sheet 198069



Part No: RBW6305G11331-3G-09

Job Qty: 1 pcs

Part Name: End Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G11331-3G Rev. C IPP Rev. A 18.05.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	1 pcs	9/20/19	9/20/19	0.25	0.06	Waterjet - Omax		dc 19/08/29
110	QC 2	1 pcs	9/20/19	9/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		dc 19/08/29
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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120 QC 8

1 pcs

9/20/19

0.00 0.00

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

DAS

81

9-89

AUG 30 2019

DAS

28

9-89

130 Packaging 3-1 - Stock - B4B 1 pcs

9/20/19

0.00 0.00

140 QC 21 - SA	1 pcs	9/20/19	0.00 0.00	Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Cut as per DWG. DWG Rev: 1

PROC Rev: 1

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100

SEP 03 2019

DWG 21 9-89

Part Op **100** - 1-Cut as per DWG. DWG. Rev: C PROG. Rev: C 2-Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location:) Identfy and Identify and Stock
140 - (QC21- Final Inspection - Work Order Release)

DAS
21
9-89

GA103

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NS.080	AISI 4130 Steel Sheet	.0060 sf (.006 ea)	100-Waterjet - Omax - 1	5075399

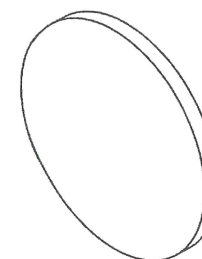
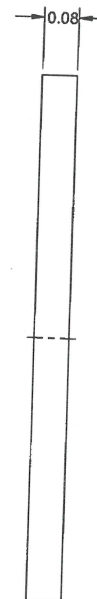
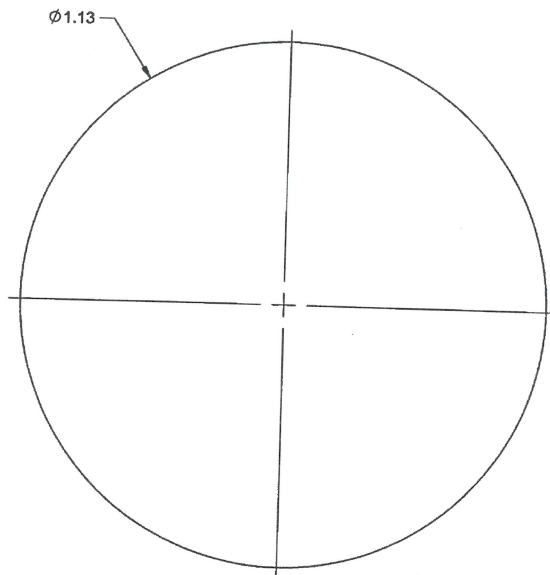
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M4130NS.080	0	18	0

Part Specifications

Specifications could not be found.

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RBW6305G11331-3G-09 END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198069 M05
19-07-22

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

C	MATERIAL A36 CHANGED FOR 4140/4142, TEMPLATE UPDATED		18-538	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VM 04/17/2018	TOOL PART #	REV. C	
CHECKED	VM 04/17/2018	RBW6305G11331-3G	SHEET 6 OF 8	
MFG. APPR.	DP 04/18/2018	TITLE	SCALE	
APPROVED	ML 04/24/2018	MAIN GEAR BOX INPUT PINION RING NUT WRENCH	NTS	
DATE	4/24/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :		Sequence #:		QTY Affected :			MRB (QSI042)		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor	
								QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
Other/Details:									

DQA:

Date: 17 MAY 2018

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐Work Order: 198069Part No. RBW6305G11331-3GNCR No. 19-7395

DISPOSITION

Rework ☒
 Scrap ☐
 Use-as-is ☐
 Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☒
 Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐
 Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
 Large Fab ☐ Composite ☐ Supplier ☐

Date:

19-11-01

Step #:

100

QTY Effective:

12

MRB (QSI042) Approval

Me
JUNE 12 / 2018

Completed By

ALAN PATRY AP
NOV 1 2019

Lead hand / Supervisor

Approval Verification

DAS
30 NOV 1 2019
9-89

QC / QA Coordinator

Approval

9
9-89
20-01-03

Description Work Order Deviation

MATERIAL TYPE TO BE CHANGED FOR
 - RBW6305G11331-3G-09 END CAP
 - RBW6305G11331-3G-11 END CAP HALF
 - REVISE MATERIAL FROM 4140/4142(28-32 Rc)
 TO 4130

Disposition

- THIS DEVIATION IS ACCEPTABLE
 - THE FIT, FORM AND FUNCTION OF THE PART
 WILL BE AS ORIGINALLY INTENDED.

Root Cause

Environment ☐ No Re-verification ☐
 Design ☒ Operator ☐
 Doc/Data ☐ Offset/Setup ☐
 Equip/Tooling ☐ Supplier ☐
 Handling/Pre ☐ Training ☐
 Material ☐ Use for Testing ☐
 Internal Transport ☐ Poor Information ☐
 Tribal Knowledge ☐ Rushing ☐
 LOA ☐ Product Improvement ☐
 Substation ☒ Process Improvement ☐
 Past Expiry Date ☐ Manufacturing Process ☐
 Misidentified ☐ Past Due ☐

Pressure/Forced ☐
 Bending ☐
 Centre Not Concentric ☐
 Cracks ☐
 Crimp/Kink/Ripple/Wave ☐
 Cuffs ☐
 Crushing ☐
 Heat Treat ☐
 Wave/Twist in Tube ☐
 Marks/Chatter ☐

FAULT CATEGORY

Temperature/Cure ☐
 Set-up ☐
 BOM/Route ☐
 Broken/Damage/Defect ☐
 Inspection Incomplete/Unqualified ☐
 Contamination ☐
 Countersink ☐
 Cut Too Short ☐
 Instructions Incomplete/Unclear ☐
 Drill Holes ☐

Power Loss/Surge ☐
 Folio/Program ☐
 Grain ☐
 Weld ☐
 Wrong Stock Pulled ☐
 Out of Sequence ☐
 Off-set ☐
 Misabeled ☐
 Fit/Function ☐
 Misaligned/off center ☐

Positioned Wrong ☐
 Outside Dimensions ☐
 Over/Under tolerance ☐
 Part Incorrect ☐
 Part Lost/Missing ☐
 Part Moved ☐
☒ Drawing ☐
 Finish ☐
 Misread ☐
 Turning Sequence ☐

OTHER:

